

## Product Data Sheet



PPG High Performance Coatings

Keeler & Long/PPG  
11605 Vimy Ridge Rd.  
Alexander, AR 72002  
PPG PMC Technical Support:  
800-661-4774

**Kolormastic™**  
**KL1000/KL1000B**  
**Aluminum**

**Product Information**

**Product Code:** KL1000 Aluminum Part A  
KL1000B Curing Agent Part B

**Product:** Epoxy-Polyamine

**Suggested Use:** A primer/finish recommended for the paint or repaint of most steel surfaces such as structural steel, tanks, bridges and piping.

**Not Recommended:** Immersion service in strong acids or alkalis.

**Product Description**

**Color:** Aluminum

**Gloss 60°:** 20-40 typically

**Weight/Gallon:** 10.3 ± 0.5 lbs./gal. (mixed)

**In Service Heat Limitations:** 200°F (93°C) maximum, dry heat

**Flash Point:** Part A 130°F (54.4°C)  
Part B 200°F (93.3°C)

**Package:** KL1000 is filled in five gallon pails at 3.0 gallons (11.4 liters) or one gallon containers at 0.75 gallon (2.84 liters).  
KL1000B is filled in one gallon containers at 1.00 gallon (3.79 liters) or quart containers at 0.25 gallon (0.946 liters).

**Percent Solids by Volume:** 84.1 ± 3.0% (mixed, calculated)

**Percent Solids by Weight:** 88.7 ± 3.0% (mixed, applied and air dried)

**VOC, Air Dried:** 139 g/L (1.16 lbs./gal.) mixed

**VOC, EPA 24:** 164 g/L (1.37 lbs./gal.) mixed

**Drying Schedule**

Air Dry @ 77°F (25°C) ASTM D5895

**Dry to Touch:** 4 hours

**Dry to Handle:** 8 hours

**Dry to Recoat:** 24 hours

Drying times listed may vary depending

on temperature, humidity and air movement.

**Application Data**

**Substrate:** Steel

**Substrate Preparation:** The service life of the coating is directly related to the surface preparation. Remove all loose paint, mill scale and rust. The surface to be coated must be dimensionally stable, dry, clean and free of contamination.

**Steel Non-Immersion:** SSPC-SP2/3 Hand/Power Tool Cleaning minimum.

**Immersion:** SSPC-SP10 (NACE No. 2) Near White Metal Blast Cleaning minimum.

**Topcoats:** Kolor-Poxy™ Hi-Build Enamels, Kolor-Poxy™ Enamels, Acrythane™ Enamels, Kolorane™ Enamels, Poly-Sil™ Enamels and Anodic Self-Priming Paints

**Application Method:** Air Spray: DeVilbiss MBC gun, 704 or 765 air cap with "E" or "EX" tip and needle or equivalent equipment. Atomization Pressure: 30-60 psi.

**Airless Spray:** Equipment capable of maintaining a minimum of 2500 psi at the tip without surge. 0.021" (0.533 mm) to 0.031" (0.787 mm) orifice.

**Brush:** Use a high quality natural bristle brush.

**Roller:** Use a 3/8" nap polyester-nylon roller cover with a solvent resistant core.

Refer to Application Guide APG-8 for additional information.

**Parts Base by Volume:** 3 parts KL1000

**Parts Catalyst by Volume:** 1 part KL1000B

**Thinner Code & Percent:** Thin up to 25% by volume with KL3700 as needed for application.

The statement and methods presented in this bulletin are based upon the best available data and practices known to PPG/Keeler & Long at the present time. They are not representations or warranties of performance, results or comprehensiveness of such data. Since PPG/Keeler & Long is constantly improving its coatings and paint formulas, future technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG/Keeler & Long Sales Representative for the most up-to-date information.

*Digestion Time:* None required

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**Application Data (continued)**

*Pot Life:* 4 hours at 77°F (25°C)

*Coverage Sq.*

*Ft./Gal. @ 1 mil:* 1349 sq. ft./gal.

*Mixing*

*Instructions:* Mechanically agitate KL1000 Part A thoroughly. Add KL1000B Part B to KL1000 Part A. Mix thoroughly until uniform.

*Wet Film Per*

*Coat:* 6.0 to 14.3 mils

*Dry Film Per*

*Coat:* 5.0 to 12.0 mils

*Clean Up*

*Solvent:* KL3700

**Additional Information**

Apply only when air, product and surface temperatures are at least 50°F (10°C) and surface temperature is at least 5°F (3°C) above the dew point.

Store materials at temperatures between 50°F (10°C) and 85°F (29.4°C).

Permissible substrate temperature during application is 50°F (10°C) and 120°F (49°C).

Read all label and Material Safety Data Sheet (MSDS) information prior to use. MSDS are available by calling 1-888-9-PPGPMC (1-888-977-4762).

Not intended for residential use.

Spray equipment must be handled with due care and in accordance with manufacturer's recommendation.

High-pressure injection of coatings into the skin by airless equipment may cause serious injury, requiring immediate medical attention at a hospital.

**WARNING!** If you scrape, sand, or remove old paint, you may release lead dust or fumes. LEAD IS TOXIC. EXPOSURE TO LEAD DUST OR FUMES CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a properly fitted NIOSH-approved respirator and prevent skin contact to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the USEPA National Lead Information Hotline at 1-800-424-LEAD or log on to [www.epa.gov/lead](http://www.epa.gov/lead). In Canada contact a regional Health Canada office. Follow these instructions to control exposure to other hazardous substances that may be released during surface preparation.